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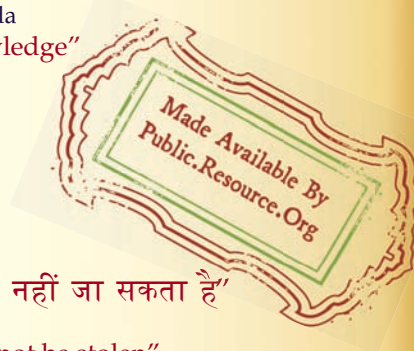
IS 3627 (1966): Cloth Rollers for Plain Cotton Looms [TXD
14: Machinery for Fabric Manufacture]



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Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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IS : 3627 - 1966

Indian Standard (Reaffirmed - 2012)
SPECIFICATION FOR
CLOTH ROLLERS FOR PLAIN
COTTON LOOMS

UDC 677.21.052.718.2



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INDIAN STANDARDS INSTITUTION
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 1

Price Rs 1.50

July 1966

Indian Standard

SPECIFICATION FOR CLOTH ROLLERS FOR PLAIN COTTON LOOMS

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AMENDMENT NO. 1 DECEMBER 1986

TO

IS:3627-1966 SPECIFICATION FOR CLOTH
ROLLERS FOR PLAIN COTTON LOOMS

(First cover page, pages 1 and 3, title) -
Substitute the following for the existing title:

'Indian Standard

SPECIFICATION FOR
CLOTH ROLLERS FOR PLAIN CALICO LOOMS'

(Page 3, clause 1.1) - Substitute the
following for the existing matter:

'1.1 This standard prescribes the requirements of
cloth rollers for plain calico looms.'

(TDC 29)

Reprography Unit, ISI, New Delhi, India

Indian Standard
**SPECIFICATION FOR
CLOTH ROLLERS FOR PLAIN
COTTON LOOMS**

0. FOREWORD

0.1 This Indian Standard was adopted by the Indian Standards Institution on 21 June 1966, after the draft finalized by the Cotton Weaving Machinery Components Sectional Committee had been approved by the Textile Division Council.

0.2 This standard is based on the manufacturing practices followed in the field in this country.

0.3 The Note under Table 1 (*see* P 6) of this standard calls for an agreement between the purchaser and the supplier.

0.4 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS : 2-1960*. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

1. SCOPE

1.1 This standard prescribes the requirements of cloth rollers for plain cotton looms.

2. TERMINOLOGY

2.0 For the purpose of this standard, the following definitions shall apply and for the definitions of terms other than those given below reference shall be made to IS : 707-1958†.

2.1 Rind Galls — Surface wounds, as from torn-off branches, covered by later growth.

2.2 Worm-Holes — The holes formed by wood-boring insects.

*Rules for rounding off numerical values (*revised*).

†Glossary of terms applicable to timber, plywood and joinery.

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3. GENERAL REQUIREMENTS

3.1 Shape — The shape of cloth roller shall generally be as shown in Fig. 1.

3.1.1 The roller shall be provided with a mild steel ruffle at each of its ends. The ruffle shall be secured to the roller by means of two wood screws placed at 180°, as shown in Fig. 1.

3.1.2 The journal shall be fixed to the roller as shown in Fig. 2 and shall be secured by means of mild steel pin.

3.2 Finish — The surface of the roller and the journals shall be smooth finished.

3.3 Freedom from Defects — The roller shall be free from knots, splits, honeycombing, cracks, gum veins, bark pocket, worm-holes, rind galls, any sign of decay, and any other defect which is likely to affect its life or usefulness.

3.4 Material

3.4.1 Roller — The roller shall be manufactured from pine wood.

3.4.2 Journals — The journals of the roller shall be manufactured from mild steel bar.

3.4.3 Ruffles — The ruffles shall be made of seamless mild steel tube (see 4.2).

4. SPECIFIC REQUIREMENTS

4.1 Dimensions — The dimensions of the roller shall conform to the requirements of Table 1 when read with Fig. 1. The tolerances on the dimensions have also been prescribed in the table.

4.2 Dimensions of Ruffles — The outside diameter D_2 of the ruffles shall be 90 ± 2 mm and width of ruffle L_2 shall be 20 ± 2 mm. The ruffle shall be 3 to 4 mm thick.

NOTE — A tube of the following dimensions specified in IS : 1239-1964* satisfies the requirements of 4.2:

NOMINAL BORE	OUTSIDE DIAMETER, mm		THICKNESS OF MEDIUM TUBE
mm	Max	Min	mm
80	89.5	88.0	4.05

4.3 Slot — The roller shall be provided with a slot running along its length (see Fig. 1). The slot shall be 10 mm wide and 10 mm deep.

*Specification for mild steel tubes and tubulars (revised).

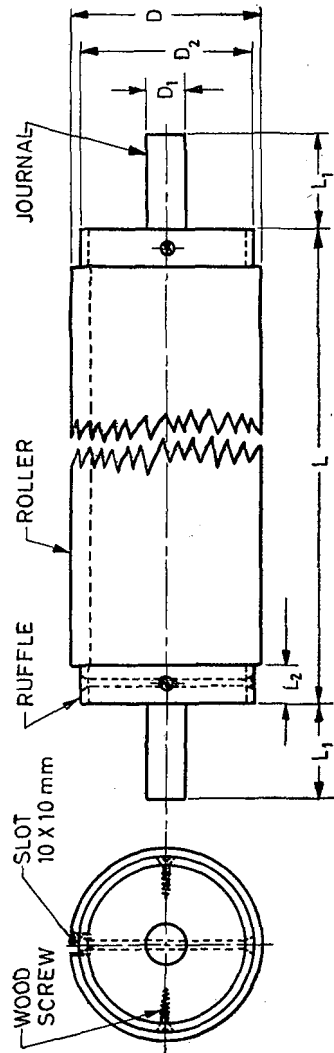


FIG. 1 CLOTH ROLLER

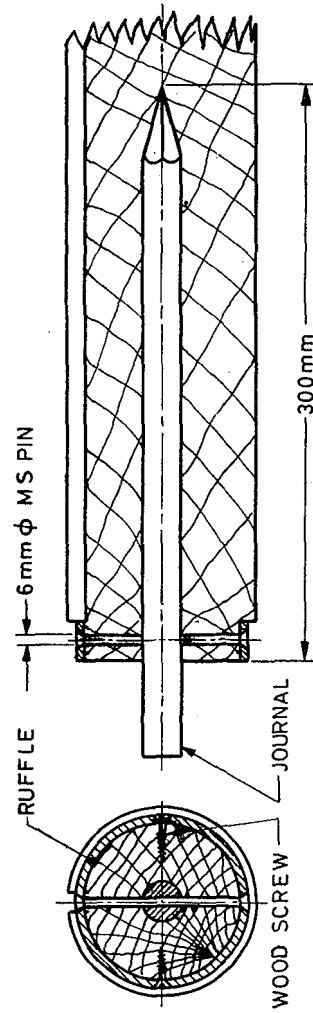


FIG. 2 DETAILS OF FIXING THE JOURNAL

TABLE 1 DIMENSIONS OF CLOTH ROLLER

(Clause 4.1)

All dimensions in millimetres.

	<i>L</i>	<i>L</i> ₁	<i>D</i>	<i>D</i> ₁
	Equal to the reed space of the loom (see Note)	50	100	20
TOLERANCES	—	± 0.4	± 0.4	± 0.4

NOTE — Reed space of the loom shall be as agreed to between the buyer and the seller. Reed spaces, in millimetres, of the looms as specified in IS : 3166-1965* are given below for the information of the buyer and the seller:

850, 950, 1050, 1150, 1250, 1375, 1475, 1575,
1675, 1775, 1875, 1975, 2075, 2200, 2300, 2400,
2500, 2600, 2700, 2800, 2900, 3100, 3300, 3600.

*Working widths and reed spaces of plain calico looms.

4.4 True Running — The cloth roller shall run true when turned on its journals. However, out of true running, if present, shall not exceed 0.4 mm.

4.4.1 The conformity of rollers to the requirements of **4.4** shall be determined by means of V-blocks and dial gauge.

5. DESIGNATION

5.1 Cloth roller shall be designated by its length *L*.

Example: Cloth Roller 850 mm

6. MARKING

6.1 Each cloth roller shall be marked at a suitable place with the following:

- a) Designation of the roller; and
- b) Manufacturer's name, initials or trade-mark.

6.1.1 Rollers may also be marked with the ISI Certification Mark.

NOTE — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution (Certification Marks) Act, and the Rules and Regulations made thereunder. Presence of this mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements

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of that standard, under a well-defined system of inspection, testing and quality control during production. This system, which is devised and supervised by ISI and operated by the producer, has the further safeguard that the products as actually marketed are continuously checked by ISI for conformity to the standard. Details of conditions, under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors, may be obtained from the Indian Standards Institution.

7. PACKING

7.1 The rollers shall be packed in wooden cases strong enough to withstand the hazards of transit. A case shall contain twelve rollers.

7.2 Each case shall be marked with the following information:

- a) Manufacturer's name, initials or trade-mark;
- b) Designation of the roller; and
- c) Number of rollers in the case.

INDIAN STANDARDS INSTITUTION

The Indian Standards Institution (ISI), which started functioning in 1947, is the national standards organization for India. Its principal object is to prepare standards on national and international basis and promote their general adoption.

The overall control of ISI, which is run and financed jointly as a non-profit making body by the Government and private enterprise, is exercised by the General Council, composed of representatives of Central and State Governments; leading trade, scientific and technological organizations; and subscribing members. The Union Minister of Industry is the ex-officio President of ISI.

The present technical activity of ISI is carried out through 8 Division Councils for Agricultural and Food Products; Chemical; Civil Engineering; Consumer Products; Electrotechnical; Mechanical Engineering; Structural and Metals; and Textile. All technical work relating to the formulation and revision of standards is done by committees appointed by and under the direction of their respective Division Councils. These committees consist of experts drawn from manufacturing units, technical institutions, purchase organizations and other concerned bodies.

To make available benefits of Indian Standards to the common man, ISI has introduced its Certification Marks Scheme under the *Indian Standards Institution (Certification Marks) Act, 1952*, as amended by the *Amendment Act, 1961*. According to this Act, quality goods conforming to Indian Standards can carry the ISI Certification Mark. This Mark is a third-party guarantee of quality of marked goods. Licences to use the ISI Certification Mark are granted to manufacturers using reliable methods of quality control subject to overall inspection by ISI.

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 Man-Made Fibre Fabrics, Handloom
 Man-Made Fibre Fabrics, Mill-Made
 Narrow Fabrics

National Flag of India
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Printed at Delhi Printers, Delhi-6, India